

Ship ASAP 08-09/096
150812

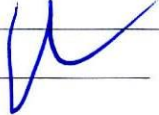
Work Order ID 150812

Wednesday, September 07, 2016 1:14:05 PM

Page 1

Item ID: D5090-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Duct Assembly
Start Date: 9/7/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/8/2016 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan:  Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5090	C

110		0.00							
110									
Small Fab									
Small Fab	Memo 1- CHECK MESUREMENTS BEFORE ASSEMBLING BRACKETS AS PER DWG BY PUTING CLEKOS. 2- ASSEMBLE AS PER DWG AND FILL UPPER AND LOWER GAPS AS SHOWN ON DWG WITH PROSEAL OR SIKAFLEX. PROSEAL BATCH# <u>1134487</u> OR SIKAFLEX BATCH: _____	0.03							
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

SEP 08 2016

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>SL</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging	<u>D350-822-013</u>								<u>SEP 08 2016</u>
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							<u>SEP 08 2016</u>
Quality Control									

DAS 21 9-89 **SEP 08 2016**

DAS 21 9-89 **SEP 08 2016**

Picklist Print

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Page 1

Work Order ID: 150812

150812

Parent Item: D5090-041

D5090-041

Parent Item Name: Duct Assembly

Start Date: 9/7/2016

Required Date: 9/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.06.18 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D5090-1		Manufactured	No				Each	28.0000		2			
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D5090-1

Bracket

DAS
6
9-89

Location	Loc Qty	Loc Code
ST227B	28	
145770	8	
149872	20	

D5090-3		Manufactured	No				Each	27.0000		2			
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D5090-3

Bracket

DAS
6
9-89

Location	Loc Qty	Loc Code
ST227B	27	
144652	1	
146037	9	
149878	17	

DAS
36
9-89

MS20470AD4-5		Purchased	No				Each	1,988.000		16			
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MS20470AD4-5

RIVET, UNIVERSAL HEAD

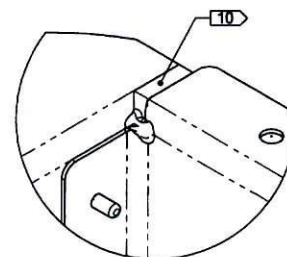
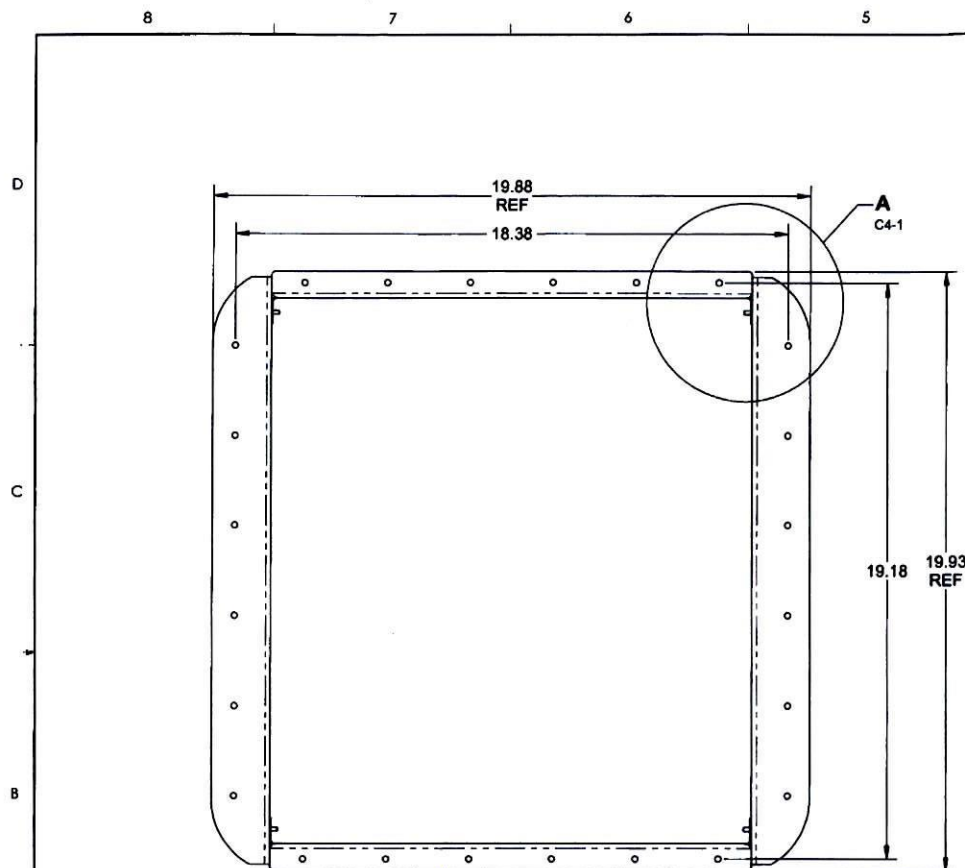
DAS
6
9-89

Location	Loc Qty	Loc Code
GA	560	
m133860	560	
ST310	1428	
m134654	1428	

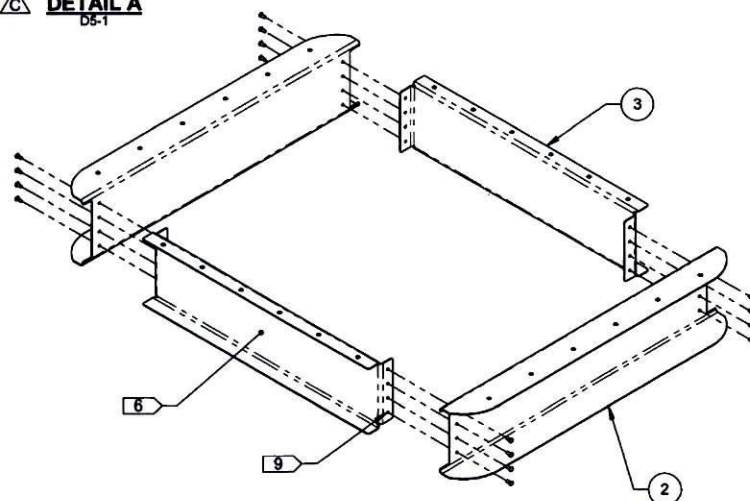
SEP 07 2016

M134848
16x

DAS
36
9-89



DETAIL A
DS-1



ITEM	QTY	P/N	DESCRIPTION
1	X	D5090-041	DUCT ASSEMBLY
2	2	D5090-1	BRACKET
3	2	D5090-3	BRACKET
4	16	MS20470AD4-5	RIVET, SOLID, PAN HEAD

D5090-041 DUCT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AFTER TRANSFER DRILLING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.85 lbs
- 8) ASSEMBLE D5090-041 WITH CLECO CLAMPS AND VERIFY DIMENSIONS
- 9) INSTALL MS20470AD4-5 RIVETS
- 10) FILL UPPER AND LOWER GAPS WITH SIKAFLEX, PROSEAL 890 OR EQUIVALENT, 4 PL

RELEASED

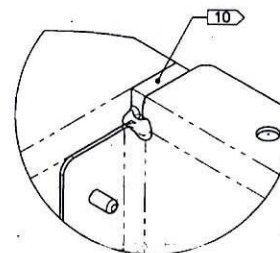
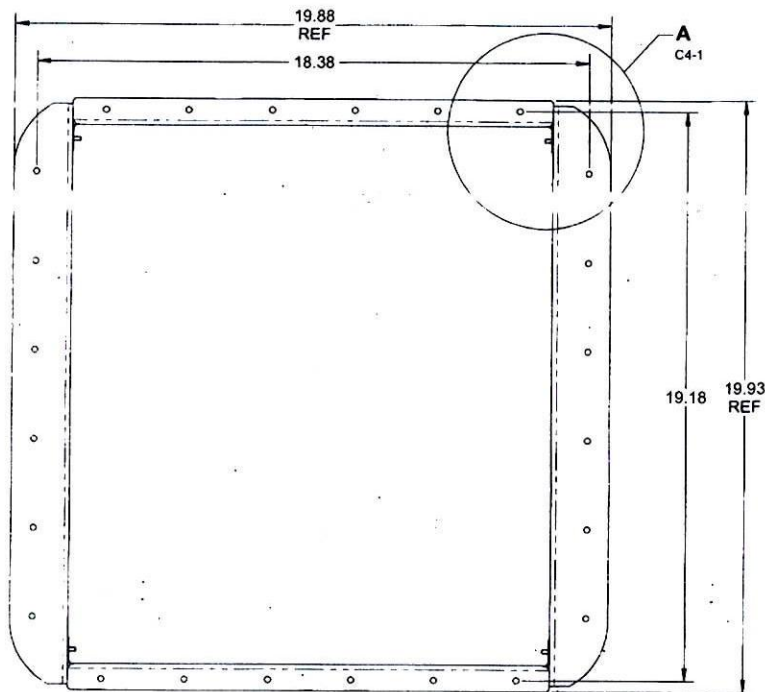
2015 APR 30

4 ECU 15-527

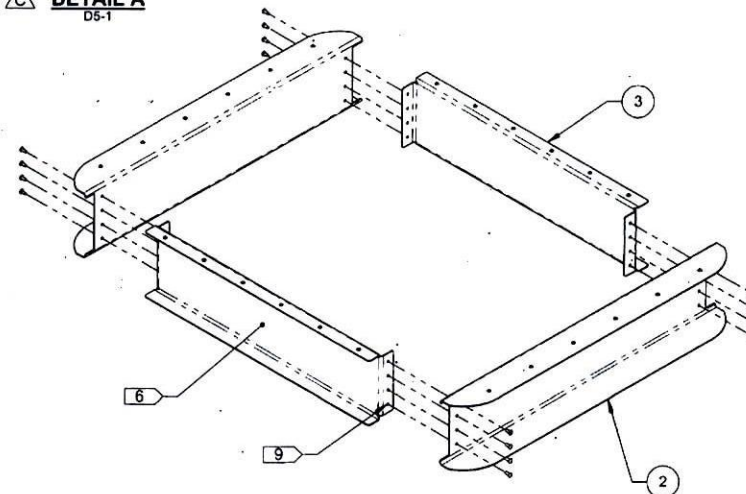
APPROVED

C	REVISED D5090-1 DIMENSION (ZN C4-2), REVISED D5090-1 GEOMETRY (ZN C2-2 AND ZN C5-2), REVISED NOTE 7 (ZN A8-2 AND ZN A8-3), REVISED D5090-3 DIMENSION (ZN C3-4), ADDED DETAIL A (ZN C4-1), REVISED NOTE 10 (ZN A8-1), REMOVED FLAG NOTE FROM TOP VIEW (ZN C7-1)	AK	14.11.25
B	REVISED D5090-3 TO ADD HOLES (ZN C6-4, ZN B5-5)	AK	14.06.27
A	NEW ISSUE	AK	14.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5090	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	DUCT ASSEMBLY	NTS
DATE	14.11.25	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O 150812



DETAIL A
D5-1



ITEM	QTY -041	P/N	DESCRIPTION
1	X	D5090-041	DUCT ASSEMBLY
2	2	D5090-1	BRACKET
3	2	D5090-3	BRACKET
4	16	MS20470AD4-5	RIVET, SOLID, PAN HEAD

D5090-041 DUCT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 7) WEIGHT: 1.85 lbs
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- 9) INSTALL MS20470AD4-5 RIVETS
- 10) FILL UPPER AND LOWER GAPS WITH SIKAFLEX, PROSEAL 890 OR EQUIVALENT, 4 PL

RELEASED

2015 APR 30

9 ECU 15-527

APPROVED

C	REVISED D5090-1 DIMENSION (ZN C4-2) REVISED D5090-1 GEOMETRY (ZN C2-2 AND ZN C5-2) REVISED NOTE 7 (ZN A8-2 AND ZN A8-3) REVISED D5090-3 DIMENSION (ZN C3-4) ADDED DETAIL A (ZN C4-1) REVISED NOTE 10 (ZN A8-1) REMOVED FLAG NOTE FROM TOP VIEW (ZN C7-1)	AK	14 11 25
B	REVISED D5090-3 TO ADD HOLES (ZN C6-4, ZN B5-5)	AK	14 06 27
A	NEW ISSUE	AK	14 04 01
REV	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D5090 REV. C SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PARTY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DRAWN	AK		
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DE APPR.	DS		
DATE	14.11.25		